

portions, and a thickness of the curled portion is substantially 1 mm greater than the thickness of the roll 2. The lower edge at the other opening 4 of the roll 2 also is inwardly curled to form a curled portion 6 which is identical in size to that of the curled portion 5. Each of the curled portions 5 and 6 is defined by paper and adhesive, and is free of any interior support ring.

***Please replace paragraph [0019] of the substitute specification with the following paragraph:***

The fiber drum D comprises the cylindrical body 1, the cover plate 7, and the bottom plate 8 made of the paper material, employing no metal. Accordingly, when out of use and discarded, the fiber drum D requires no traditional separation into paper and metal. As the curled portions 5 and 6 are inwardly curled, they develop no tension towards the radial direction and will be prevented from generation of flaws as compared with outwardly curled portions. The curled portions 5 and 6 are tilted radially and outwardly of the cylindrical body 2 and can thus be joined to the cover plate 7 and the bottom plate 8 more closely while being covered with their respective tightening bands 9 and 10. This eliminates the need of specific seals or packings. While the curled portions 5 and 6 of the cylindrical body 1 according to the present invention are rigid enough without being pressed down, their pressed-down structure having no hollow space will contribute to increased physical strength of the cylindrical body 1. Moreover, the difference between the curled portions 5 and 6 and the other portion of the cylindrical body 1 (i.e. dimension "t" as shown in Fig. 2) is as small as 1 mm. Stated otherwise, a radial distance between a line that is tangent to an inner circumferential surface of the curled portion 5 or 6 and a line defined by an inner circumferential surface of the cylindrical body 1 is represented by dimension "t" and is no greater than 1 mm. Accordingly, because of this small distance the inner side of the cylindrical body 1 is less undulated such that any content such as powder can successfully be removed from the fiber drum D without being trapped.

***Please replace paragraph [0029] of the substitute specification with the following paragraph:***

This is followed by retracting the first chuck 16a from the curled portions 5 and 6 and lowering the pressing member 14 further as shown in Fig. 8. As moved along the tapered surface 21 of the outer side of the forming die 15, the curled portion 5 is turned outwardly such that the curled portion forms an angle with an outer surface of the roll 2 that is between 0° and 180°. If the tilting angle is too large, the curled portion 5 may have flaws extending radially. When the tilting angle is too small, the effect of a tightening band or the like will be diminished. It is thus essential to determine an appropriate angle of tilting for ensuring the effect of the tightening band and eliminating the generation of flaws.

***Please replace paragraph [0030] of the substitute specification with the following paragraph:***

As shown in Fig. 9, the tilted curled portion 5 is held directly in contact with the tapered surface 21 of the forming die 15, and then the second chuck 16b is advanced in the direction X denoted by the arrow in Fig. 9 to press down the curled portion 5 so as to form a pressed curled portion that forms an angle with the outer surface of the roll 2 that is between 0° and 180°. Any hollow space in the curled portion 5 may decrease the physical strength at the opening of the roll 2. The pressing down of the curled portion 5 may require a pressing force of 30 tons. The cylindrical body 1a of this embodiment is rigid enough and its physical strength may be increased by pressing down the curled portions 5 and 6 to eliminate any hollow space.